. 5/24

DART AEROSPACE LTD	Work Order:	23246
Description: Outer Aft Saddle	Part Number:	D5955
Drawing: D5955 Rev. A	Qty:	B

Step	Location	Procedure	Βv.	Date	Qty
1	EXPEDITING	Issue Work Order	11		6
		Dwg. not required	HXH	05.05.11	0
2	STORES	Issue material from stock: D6101-013 (7075-T7351)	10		
		Cut Size 2.50" x 10.10" X 8.25" (Grain along 10.10") 321600	_ 4	, , ,	İ
		• Batch: B23537	Int	05/07/06	8
3 .	HAAS ///	Setup-W/Q No.	1111		
		Setup Inspection last completed by	1/1/1		
4	HAAS	Machine as per folio D5955	10		
ļ <u>.</u>		Ensure Batch Number is entered	12	US-07-0	88
5	HAAS	Deburr and Tumble	1		
		<u> </u>	a	05-07-0	8
6	-QC	Inspect Level 1			
<u> </u>		Fill Out Inspection Sheet	a	05°07.5	5 8
7	QC	Inspect Level 8	_ ,_		
		Audit Inspection Sheet	$\Box D$	65.020	18
8	METAL	Acid etch and alodine as per QSI 005 4.1	1		
<u> </u>			88	05.07-11	S
9	FINISHING	Powder Coat White (Ref. 4.3.5.1) as per Dart QSI 005 4.3	1.11		V
<u> </u>	,		m	05 07 11	Ŏ
_ 10	QC-	Inspect Level 3	19		_
ļ	07077		CX	05/07/1	8
11	STORES	Pack in foam, identify and stock	4		
		· · · · · · · · · · · · · · · · · · ·	1200	5107/11	8
12	EXPEDITING	Close Work Order 226.41	42	25/07/14	78
• •		Cost / Part 226.41	10	35/01/H	<u> </u>

Rev	Date	Change	Revised By	Approved
Α	97.03.05			7.151.01.00
BĴ₄	99.04.19	Re-format	DM	
С	100.06.22	Removed P/O for powder coat	EC ,	-
D	02.02.06	Added D part # and inspect level 21	NG	#

RELEASED

OZ/OZ/O6 ///

W/O:		WORK ORDER C	HANGES					
DATE	STEP	PROCEDURE CHANGE	1	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC inspector
					,			

NCR:		W	ORK OR	DER NON-CONFORMANCI	E (NCR)			
		Description of NC		Corrective Action Section B	•	Verification	Approval	Approval
DATE	STEP	Section A			Sign & Date	, Section C	Design Mgr	QC Inspector
5-07-°	4	- 1 part sevap, power falliume caused spindle head to	Propert	Scrap: replace	2	2	worsens	05:02.11
		drop 0.125".	No ob a	•	05-07-11	05-07-11	200	ω · γ- ₁₁
				est >				•
						1		
		6 ,				L		

Part No:	PAR #: Fault Category:	NCR:	Yes No DQA:	Date: <u>05/07/12</u>
NOTE: Date & initial all entries	*		QA: N/C Closed:	Date:

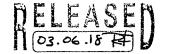
DART AEROSPACE LTD	Work Order:	23246
Description: Outer Aft Saddle	Part Number:	D5955
Inspection Dwg: D5955 Rev. A		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D5955 Rev. A and record below:

				Re	corded Actu	ıal Dimensio	ons		
Dim _.	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Dațe
Α	0.438	0.443	DT8682		-				
В	1.745	1.755		1.749	1.750	1.750	1.700		
С	5.245	5.255		5.248	5.250	5.249.			•
D	6.995	7.005		4.998	6-999	6-948	7.000		. •
Ē	5.745	5.755		5,747	5-700	5.700			
F	4.745	4.755		4.748	4-750	4-700	4.200		
G	0.313	0.318	DT8686					-	
Н	1.522	1.532		1.525	1.525	1-524	1.5Lb		
1	3.048	3.058		3.053		3 2003	3.052		
J	4.575	4.585		4.582	4-582	4.582	4.082		
K	0.313	0.318	DT8686)		
L	0.240	0.260		0.252	0,257	0.252	0.252		
M	0.490	0.510		0.503	6.498	0.495	0.501		
N	0.240	0.260		0.251	0.256	0-251	0.251		
0	7.990	8.010		8.000	8.002	8-002	8-002		
Р	0.240	0.260		0.255	0.253	0.253	0.248		
Q	0.307	0.312		0.3//	0.310	0.310	0.310		
R	0.760	0.765		0.760	0.761	0.761	0.761		
S	0.490	0.510		0.501	0.509	0.508	0.508		
T	1.625	1.645		1.640	1.640	1.635	1.638		
Ū	2.000	2.020		2.005	2,005	2002	2-001		
V				700	200		<i></i>		
W				<u> </u>					
X					**				
Y					**				
Z									
AA				 					
AB				 					
AC									
AD			*			****		•,	
AE								ومرهب	
AF				†					
AG					·				
AH							* 2		
	Acc	ept/Reje	ct						L

Measured by:	Audited by	212
Date: 05-07-	Of Date:	05.07.68

Rev	Date	Change	Revised by	Approved
Α	99.04.19	New Issue	RF ,	.//
В	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF ₹	4



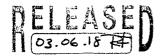
DART AEROSPACE LTD	Work Order:	23246
escription: Outer Aft Saddle	Part Number:	D5955
Inspection Dwg: D5955 Rev. A		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D5955 Rev. A and record below:

		·		Re	Recorded Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.438	0.443	DT8682	<u> </u>					_
В	1.745	1.755		1,700	(-757	1-749	1,750		
С	5.245	5.255		5.250	5-280	5.249	5.258		
D	6.995	7.005		6.999	7.00	7-001	7.000		
E	5.745	5.755		5.750	5-700	5.751	5.750		
F	4.745	4.755		4350	4.749	4.750	4-749		
G	0.313	0.318	DT8686	•					
Н	1.522	1.532		1.526	(-527	1-028	1-528		
ı	3.048	3.058		3-052	3-052	3.052	3.052		
J	4.575	4.585		4-580	4.080	9.580	4.560		
K	0.313	0.318	DT8686				-		
L	0.240	0.260	,	6.252	0.251	0.251	0.250		
М	0.490	0.510		0.500	0.497	0.498	0.500		· · ·
N	0.240	0.260		0.252	0.257	0.257	0.257		
0	7.990	8.010		8,00(8.001	8.001	8,001		
Р	0.240	0.260		0-247	0.249	0248	0.248		
Q	0.307	0.312		0-310	6.310	0-3 io	0.310		
R	0.760	0.765		0.74	295.0	0.760	0.761		
S	0.490	0.510		0.508	0.492	0.208	0.508		
Т	1.625	1.645		1.638	1.6383	1.138	ار له 3۶		
U	2.000	2.020		2-002	2-004	2004	2.002		
V									
W									
X									· · · · · · · · · · · · · · · · · · ·
Y			· · · · · · · · · · · · · · · · · · ·						
Z									
AA	-		THE PARTY OF THE P					···	
AB								_	
AC						7			
AD									
AE									
AF									
AG									
AH									
	Acc	ept/Reje	et			-			

Measured by:	Audited by S
Date: 65-07.68	Date: のう・0プーのと

Rev	Date	Change	Revised by	Approved
Α	99.04.19	New Issue	RF .	.//
В	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF R	



Job Costing Report

Dart Aerospace Ltd. Hawkesbury

May 09, 2005 02:16 pm

Work Order No : 0023246

Project Name : D5955 Project For : WK524 Work Order Type : Main

Main WO Number

House Part Number : D5955

Description : Saddle

Manufactured : Yes Amount Req'd:

Amount Done :

Start Date : 05-09-05

Est Finish Date : 06-10-05 Act Finish Date

Approval Rec'd :

Ō

Drawings Reqd : No Ok for Approval :

Department Code:

Burden Flags : NNNNNNN WO Status : Open

Invoice State : Not Invoiced

Invoice Date :

Invoice Number :--

Invoice Amount : 0.00

Order Entry No:

OE Value 0.00

Est Mark Up : 0.000% Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

		Estimated	Actual	Var. %	Posted	To Post	
Material Cost	= = : :	0.00	0.00	0.00	0.00	0.00	=
Engineering Hours	:	0.00	0.00	0.00			
Engineering Cöst	:	0.00	0.00	0.00	0.00	0.00	
Production Hours	:	, 0.00	0.00	0.00			
Production Cost	:	0.00	0.00	0.00	0.00	0.00	
Packaging Hours	:	0.00	0.00	0.00			
Packaging Cost	:	0.00	0.00	0.00	0.00	0.00	
OverHead Hours	:	0.00	0.00	0.00			
OverHead Cost	:	0.00	0.00	0.00	0.00	0.00	
CNC Hours	:	0.00	0.00	0.00			
CNC	:	0.00	0.00	0.00	0.00	0.00	
Misc. Hours	:	'0.00	0.00*	0.00			
Misc.	:	0.00	0.00	0.00	0.00	0.00	
		========	========	=======	•		
· Burden	:	0.00	0.00	0.00			
•		========	========	======	-		
Total Cost	:	0.00	0.00	0.00			
Mark up	:	Ó.000	0.000				
Selling Cost	:	0.00	0.00		•		

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00